

**Work Order ID 63806**

Monday, November 15, 2010 8:35:05 AM



Page 1

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 11/15/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/11/16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3436	Rev A

100



Large Fab

Large Fab

Memo

0.00

0.00

  
11/01/13

3



110



BAND SAW

Bandsaw

Memo

0.00

0.00

  
11/01/13

3



Jeaspa Bandsaw

1- Slit part D3436-041 on bandsaw as per Dwg D3436  
deburr

□2-

120



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

0.00

  
11/01/14

3


  
BE 11/01/14

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 uor114

+3

CN

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

M115851

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME: 10:45

OVEN TEMPERATURE: 100°

FINISH TIME: 11:15

Wing Walk batch: M115390

M

11/01/17

3 BK 11-01-17.

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 Ø

BB/10/18 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept



Setup Start



Stop



Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

155



Small Fab

Small Fab

Operation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

0.00

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/10

43

44

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

PPG638081P

0.00

PPG6480F2P

11/11/10

(3)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 11/22/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

180



QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

  
 11-01-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Monday, November 15, 2010 8:35:09 AM

Page 1

Work Order ID: 63806



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP A 05.05.11 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-1 		Manufactured	No			100	Each	49.0000	1	3		<i>11.01.13</i>	
Clamp													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							WA	49				<i>3</i>	
								49					
D3436-3 		Manufactured	No		<u>17679</u>	100	Each	4.0000	1	3		<i>11.01.13</i>	
Left Step													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							WA	4				<i>3</i>	
								4					
D3436-5 		Manufactured	No		<u>56841</u>	100	Each	19.0000	4	12		<i>11.01.13</i>	
Bushing													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							WA	19				<i>12</i>	
					<u>364065</u>			19					
					<u>56893</u>			19					
D3436-9 		Manufactured	No			100	Each	6.0000	2	6		<i>11.01.18</i>	
Pad													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST056	6					
								6					
							<u>56830</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, November 15, 2010 8:35:09 AM

Page 2

Work Order ID: 63806



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 11/15/2010

Required Date: 11/22/2010

Start Qty: 3.00

Required Qty: 3.00

D3436-7



Manufactured No

160

Each

40.0000

1

3



Cap

*PL 11.01.13*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	40	
<u>56836</u>	40	<u>3</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

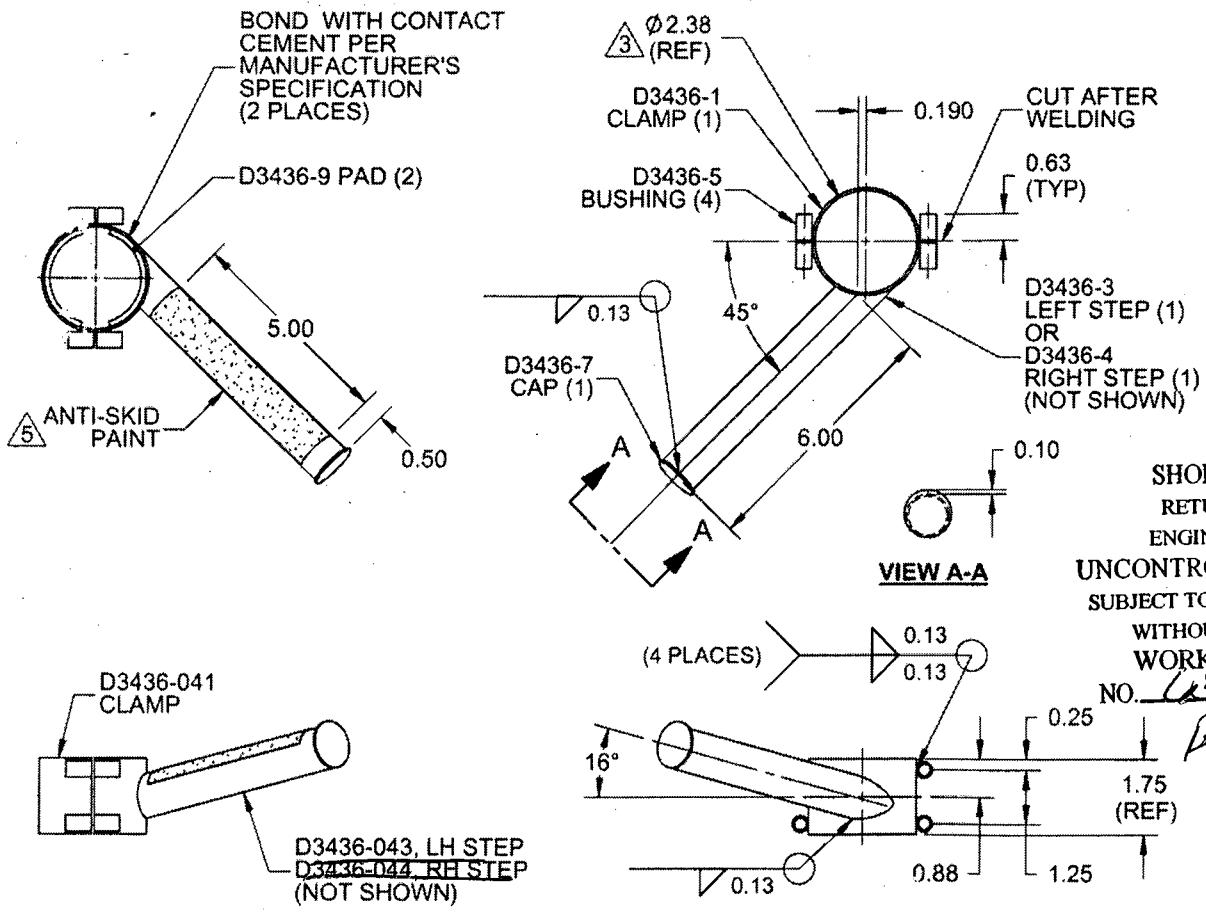
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A	SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4	
A	05.04.28	NEW ISSUE		



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27 *MM*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

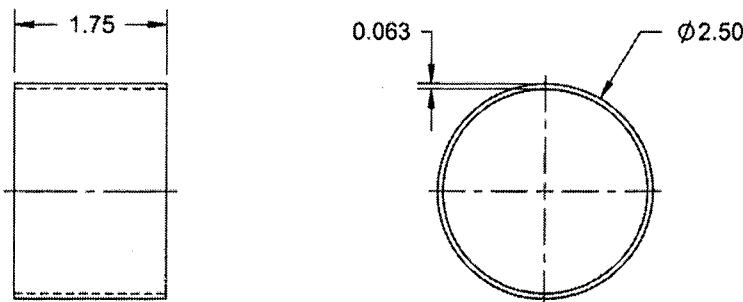
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CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3436	REV. A	SHEET 2 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2	

*WU 63809*



### D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



### D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

*05-05-27 ff*

### D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

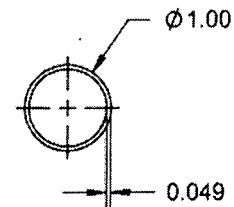
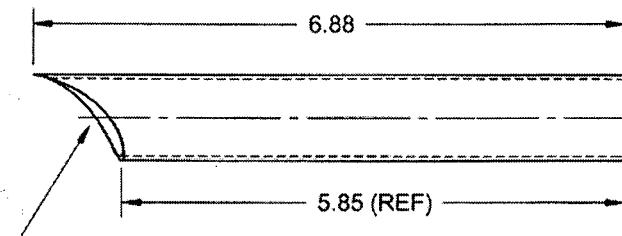
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NOTE: Date & initial all entries

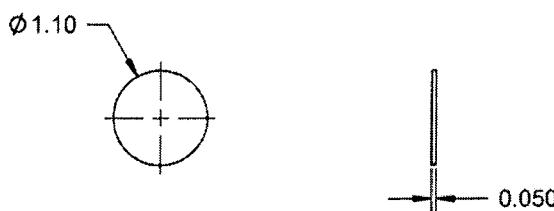
**DART**

DESIGN MB	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3436	REV. A	SHEET 3 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2	

*WB 43804*MAKE CUT-OUT AS PER  
TEMPLATE DT8771**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)

**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

**RELEASED***05-05-27 ff***D3436-3/ -7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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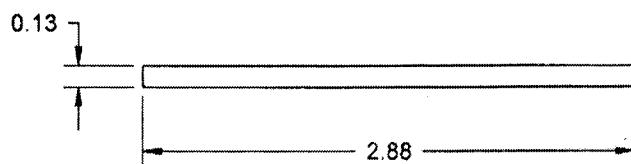
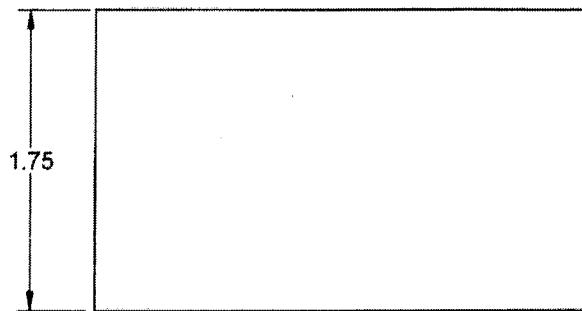
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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3436	REV. A	SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP	SCALE 1:1		

*w/o 43866*



RELEASED  
05-05-27 *MM*

### D3436-9 PAD

#### NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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